

Work Order ID 59639

Wednesday, June 09, 2010 9:46:09 AM



Page 1

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 6/9/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 10-6-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100	FLOW WATER JET	0.00							
	Waterjet	Memo	0.00						
FLOW CNC Waterjet	1-Cut as per Dwg D3296	<input type="checkbox"/> Dwg Rev: A	<input type="checkbox"/> Prog Rev: A	<input type="checkbox"/> 2-					
2024 .063	Deburr if necessary								

B 10-6-23

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	Memo	0.00						
Quality Control									

B 10-6-23

120	QC8- Inspect parts - second check	0.00							
	QC	Memo	0.00						
Quality Control									

8106624

(X16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Required Date: 6/17/2010 Req'd Qty: 12.00




Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab Small Fab	Small Fab Memo Deburr	0.00 0.00							
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

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Page 3

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Required Date: 6/17/2010 Req'd Qty: 12.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>186</u>	0.00							
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/06/28
ME
10-6-28

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, June 09, 2010 9:46:13 AM

Page 1

Work Order ID: 59639

Parent Item: D3296-3

Parent Item Name: Door Panel

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:E Now on Waterjet 06-11-02 JLM

Start Date: 6/9/2010

Required Date: 6/17/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	133.9000	0.6532	8.250947	10.5		



2024-T3 .063 sheet



1810-6-23

Location

Loc Qty

Loc Code

MAT22

133.9

113866

19.2

114351

114.7

114351

16

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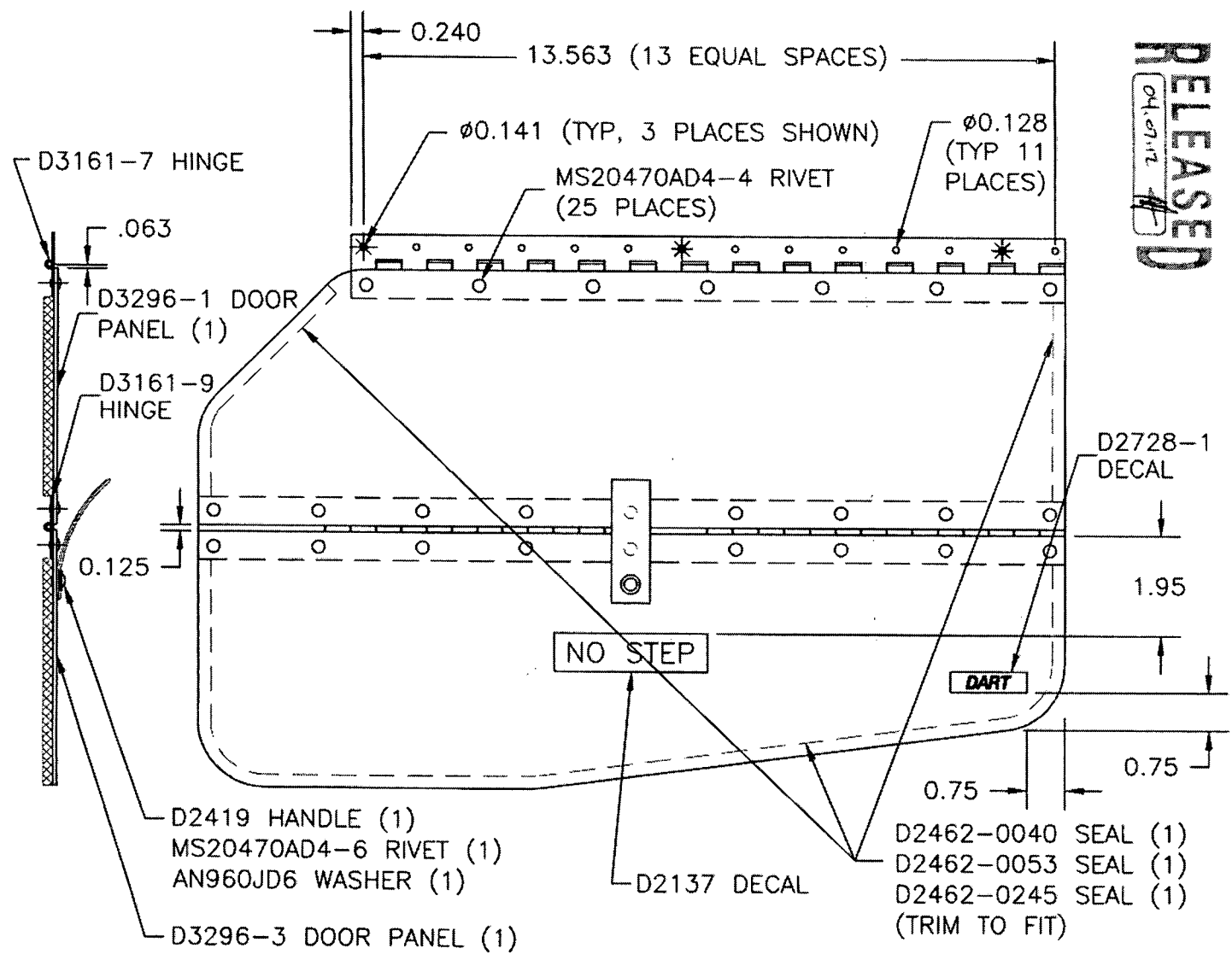
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NO. 3-9
10-6-09



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CHECKED	APPROVED	DRAWING NO.
DATE		D3296
04.06.28		TITLE
A	04.06.28	DOOR ASSEMBLY
		NEW ISSUE
		SCALE
		1:3
		REV. A
		1 OF 2



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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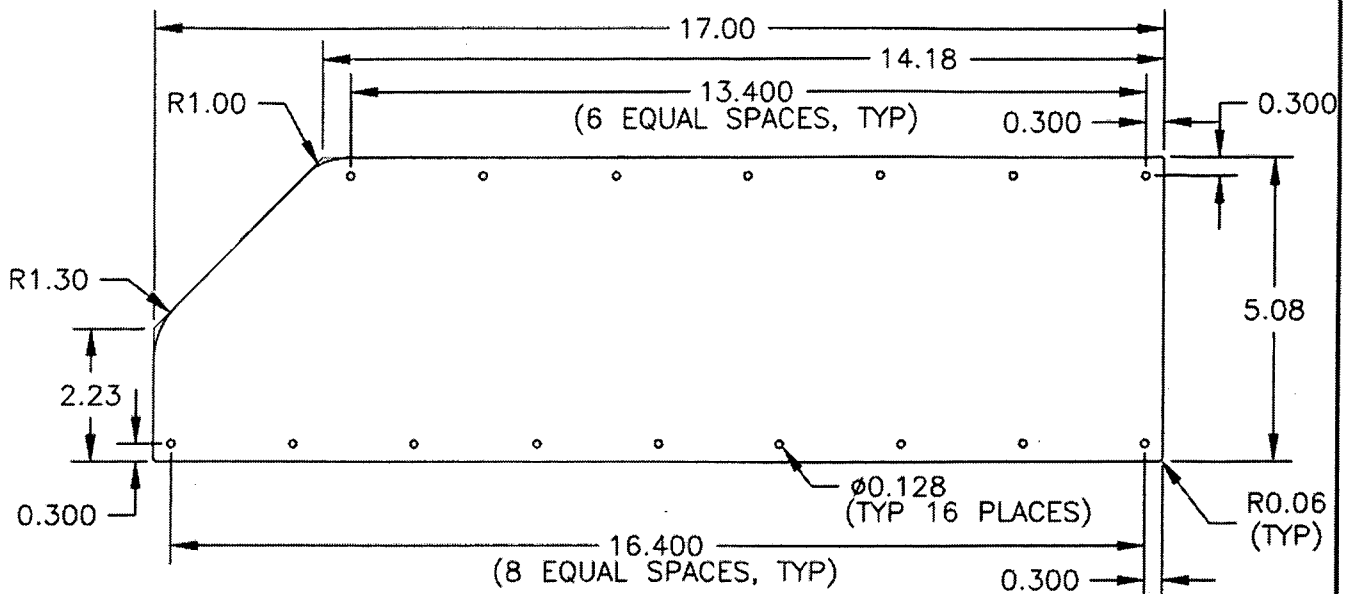
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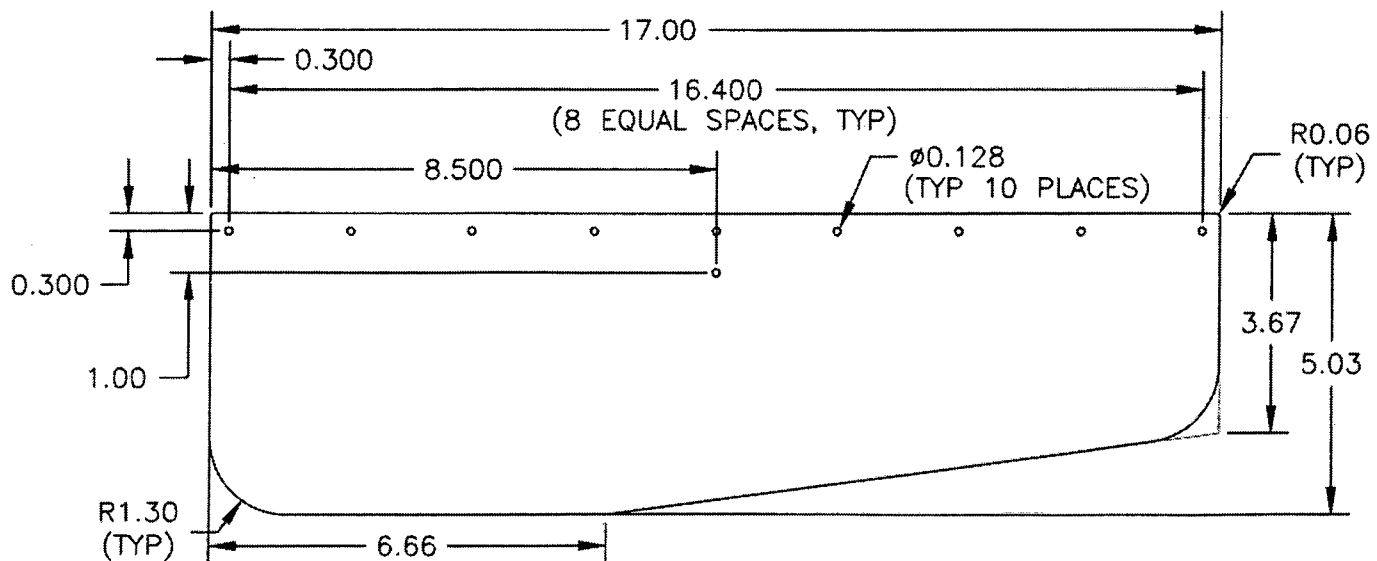
w/0 59439



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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